












Date: Wednesday, 3/26/2008 1:45:54 PM  
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HELI-UTILITY BASKET RH
Job Number	: 38216		
Estimate Number	: 13190		
P.O. Number	:	Part Number	: D205541046
This Issue	: 3/26/2008 S.O. No. :	Drawing Number	: IIN D205-541 REV G
Prsht Rev.	: NC	Project Number	:
First Issue	: 1 / Type : LARGE FAB ASSY	Drawing Revision	: G
Previous Run	: 37724	Material	:
Written By	:	Due Date	: 4/16/2008 Qty: 1 Um: Each
Checked & Approved By	: <u>JD 08.3.27</u>		
Comment	: Est Rev:A new issue 08-02-15 DD verified by: Est Rev:B Ecn 1157 08-03-19 DD verified by:		

Additional Product

Job Number:			
Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	
			
Comment: Photocopy bluefile & type labels per PPPD205-541-046		CHG001	08.04.10 JD
2.0	D3712042	LOW PROFILE BASKET BASE ASSEMBLY	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) LOW PROFILE BASKET BASE ASSEMBLY batch <u>B 38217</u>		<u>ml 08/04/09</u>	
3.0	D3713042	LID ASSEMBLY	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) LID ASSEMBLY batch <u>B 38218</u>		<u>ml 08/04/09</u>	
4.0	D2258300	Placard	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Placard Batch: <u>16384</u>		<u>SC</u>	
5.0	D2332041	Lid Prop Assembly 6.69"	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Lid Prop Assembly 6.69" Batch: <u>36819</u>		<u>8/4/7</u>	<u>SC</u> <u>(K)</u>

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
<del>08/04/09</del>	<del>22</del>	<del>2 D 3257-1 B 38068</del> <del>6 AW3-11A M 114820</del> <del>4 AW 9605 A10 M 107534</del> <del>6 MS21042L3 M 106883</del>	<del>SB</del>	<del>08/04/09</del>	<del>1</del>			
		<del>2 D 2931 B 21139</del> <del>2 AW 9605 P 8 M 107091</del> <del>2 MS 20600 AD 44-3 M 18071</del>						

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-UTILITY BASKET RH

Job Number: 38216

Part Number: D205541046

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2530

Handle Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Handle Weldment  
Batch: 3665A

SP

7.0

D2535

Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Spring  
Batch: 36397

SP

8.0

D2537

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Bushing  
Batch: 36853

SP

9.0

AN316A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Bolt  
Batch: M168C5

SP

10.0

AN420A

Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)  
Bolt  
batch: M16895

SP

11.0

AN422A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Bolt  
Batch: M104937

SP

12.0

AN424A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Bolt  
Batch: M104547

8/4/7

SP

64

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-UTILITY BASKET RH

Job Number: 38216

Part Number: D205541046

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

AN517A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M107242

SP

14.0

AN960JD416

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Washer

Batch: M106780

SP

15.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch: M106654

SP

16.0

AN960JD416L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch M107008

SP

17.0

AN9704

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch: M105442

SP

18.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch: M106885

SP

19.0

MS21042L4

Nut



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Nut

Batch: M106825

8/4/17

SP

(1x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/26/2008 1:45:54 PM

User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-UTILITY BASKET RH

Job Number: 38216

Part Number: D205541046

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M106277

8/4/7

SP

21.0

D37231

BUSHING



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

FWD PLATE 37479

batch B 32550

(2)

B 38229

(4)

SB 08/04/09 (1)

22.0

SMALL FAB 1

SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

-Assemble as per IIN 205-541-046

ml 08/04/09 x1

23.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/04/09 (4)

24.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

25.0

D21991

Struts, 19"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Struts, 19"

Batch: 37742

SP

26.0

D219923

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Strut

Batch: 1329387

8/4/7

SP

(12)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-UTILITY BASKET RH

Job Number: 38216

Part Number: D205541046

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

D219925

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Strut

Batch: B37537

SP

28.0

D2498

Mounting Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Mounting Bracket

Batch: B17625

SP

29.0

D2499

Mounting Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Mounting Bracket

Batch: B27501

SP

30.0

D2515

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bushing

Batch: B10742

B29138

SP

31.0

D30521

Mounting Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Mounting Lug

Batch: M18143

SP

32.0

AN47A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M10248

SP

33.0

AN412A

Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Bolt

Batch: M105143

8/4/1

SP

(1x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-UTILITY BASKET RH

Job Number: 38216

Part Number: D205541046

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

AN413A

Bolt



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

Bolt

Batch: M106993

SP

35.0

AN414A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M105653

SP

36.0

AN57A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: M106785

SP

37.0

AN513A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: M109936

SP

38.0

AN960JD416

Washer



M106780



Comment: Qty.: 27.0000 Each(s)/Unit Total : 27.0000 Each(s)

Washer

SP

39.0

AN960JD516

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Washer

Batch: M106654

SP

40.0

MS21042L4

Nut



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Nut

Batch: M106825

8/4/17

SP

(14)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-UTILITY BASKET RH

Job Number: 38216

Part Number: D205541046

Job Number:



Seq. #:

Machine Or Operation:

Description :

41.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch: M106271

8/4/17

SC

(X)

42.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

08/04/09

43.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-541-046

Location:

PPP Rev:

Draft

8/4/17

SC

(A)

44.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/10

Job Completion



mf 08-04-10

h

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

...CONTINUED FROM PREVIOUS PAGE

Qty -043	Qty -044	Qty -045	Qty -046	Part Number	Description
2*	2*			MS20600AD4W3	RIVET
2*	2*	2*	2*	MS21042L3	NUT (OR MS21042-3)
4*	4*	5*	5*	MS21042L4	NUT (OR MS21042-4)
16	16	16	16	MS21042L4	NUT (OR MS21042-4)
4*	4*	4*	4*	MS21042L5	NUT (OR MS21042-5)
2	2	2	2	MS21042L5	NUT (OR MS21042-5)

\* = ASSEMBLED AT DART

## 6.0 PARTS LIST HELI-ACCESS-STEP™

Qty -047	Qty -048	Part Number	Description
X		D205-541-047	HELI-ACCESS-STEP, LH
	X	D205-541-048	HELI-ACCESS-STEP, RH
1		D3724-041	STEP ASSY, LH
	1	D3724-042	STEP ASSY, RH
2	2	D3731-1	PLATE
2	2	D3751-1	SHIM
6	6	AN4-13A	BOLT
6	6	AN4-14A	BOLT
24	24	AN960JD416	WASHER
12	12	MS21042L4	NUT (OR MS21042-4)

## 7.0 OPTIONAL EQUIPMENT

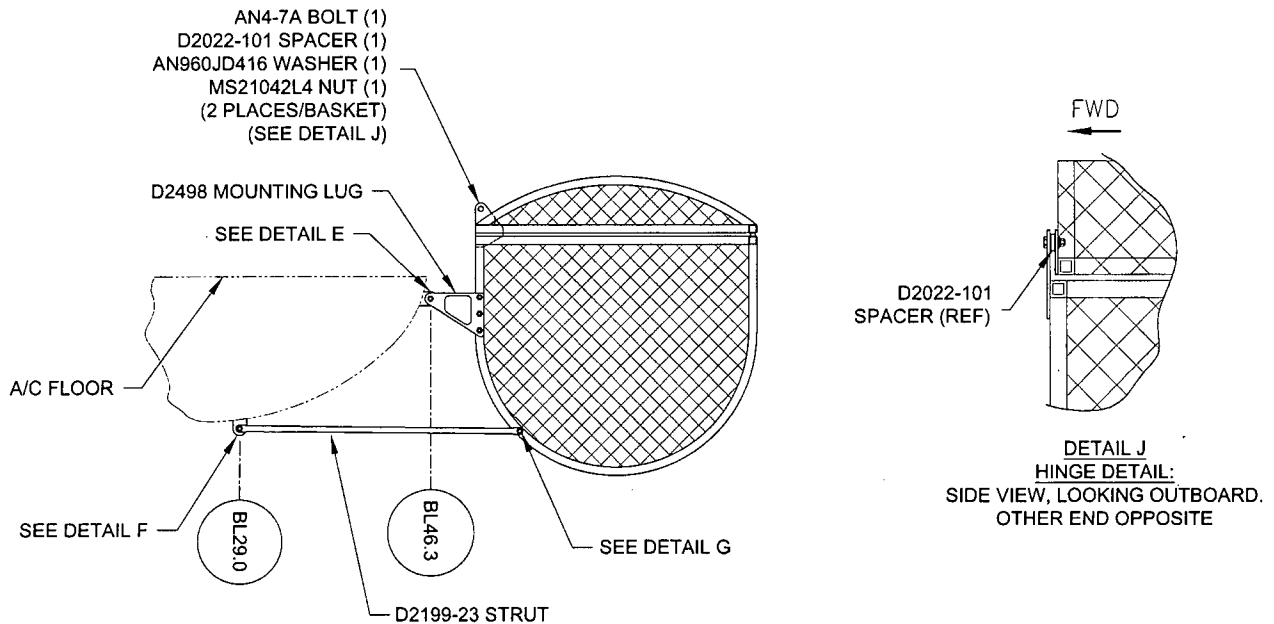
Qty -049	Part Number	Description
X	D205-541-049	LINER KIT
1	D2446	SIGN PLATE
1	D2509	LINER (BASE)
1	D2511	LINER (END)
6	MS24693S272	SCREW
6	A3235-020-935	WASHER
6	NAS679A3W	NUT
4	MS20470AD4-8	RIVET
42	MS20600AD4W4	RIVET

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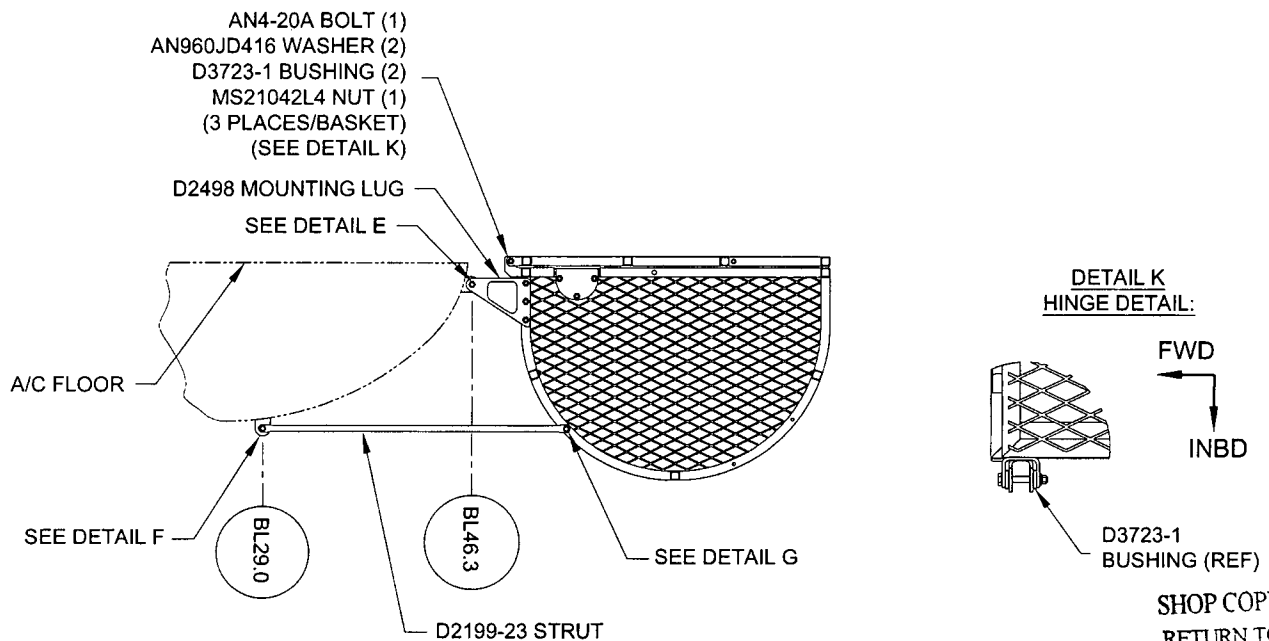
Revision: **G**  
Date: 08.03.04

WORK ORDER  
NO. 32216



**Figure 2a - Section A-A Looking Fwd at STA 84.29**

(D205-541-044 Shown; D205-541-043 Opposite)



**Figure 2b - Section A-A Looking Fwd at STA 84.29**

(D205-541-046 Shown; D205-541-045 Opposite)

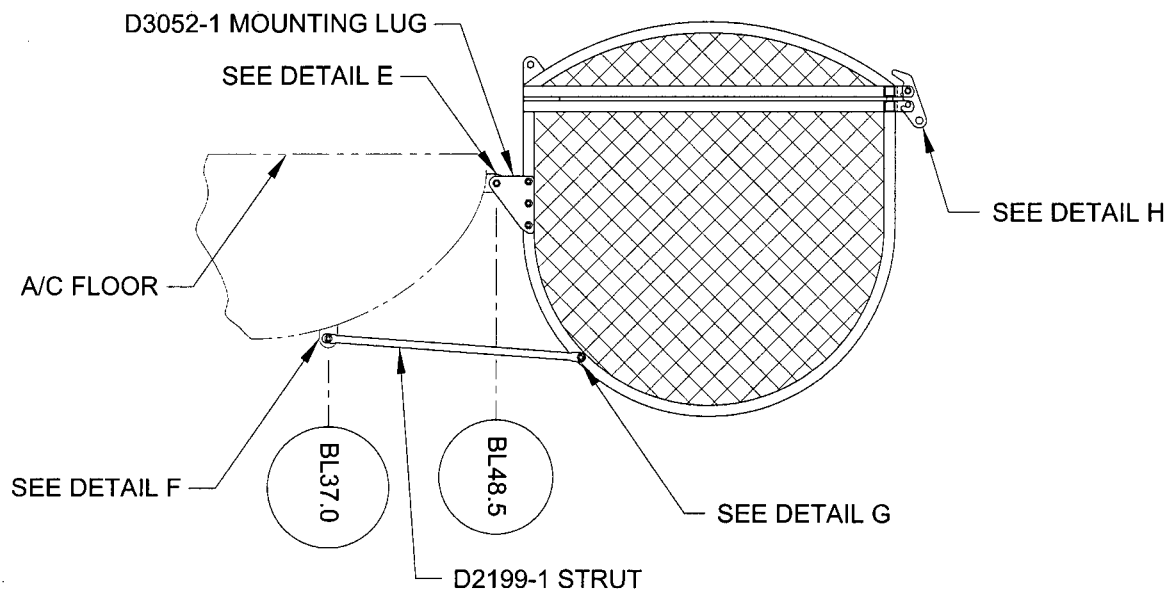
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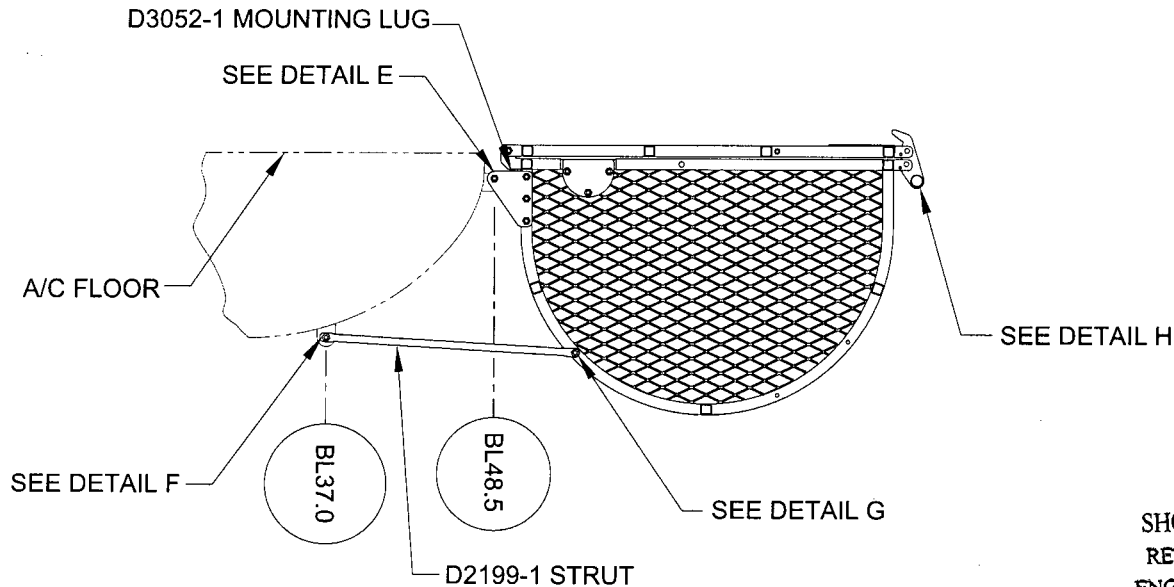
NO. 38216





**Figure 3a – Section B-B Looking Fwd at STA 129.00**

(D205-541-044 Shown; D205-541-043 Opposite)



**Figure 3b – Section B-B Looking Fwd at STA 129.00**

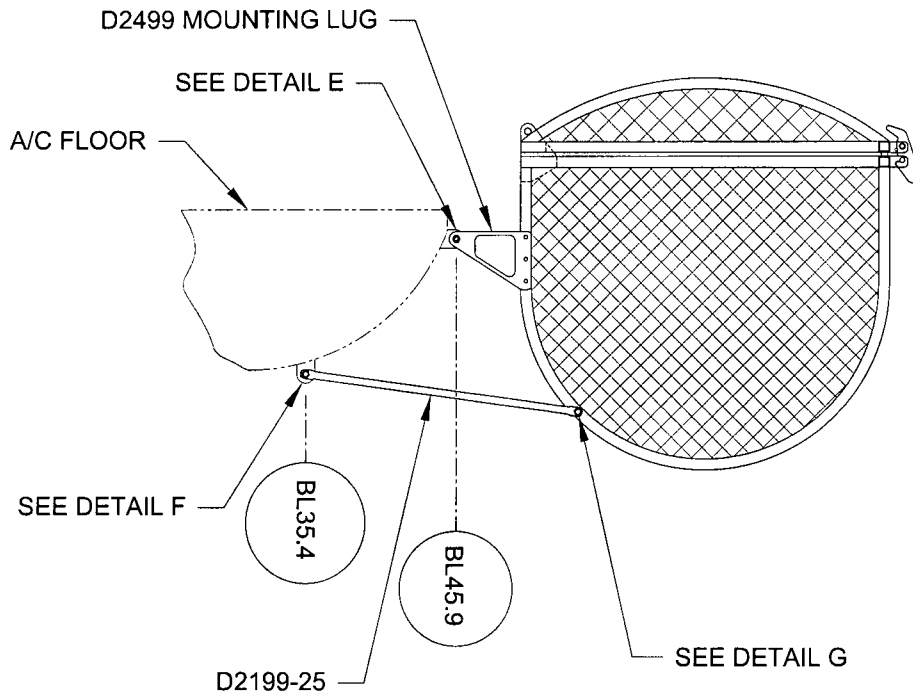
(D205-541-046 Shown; D205-541-045 Opposite)

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NO. 38216

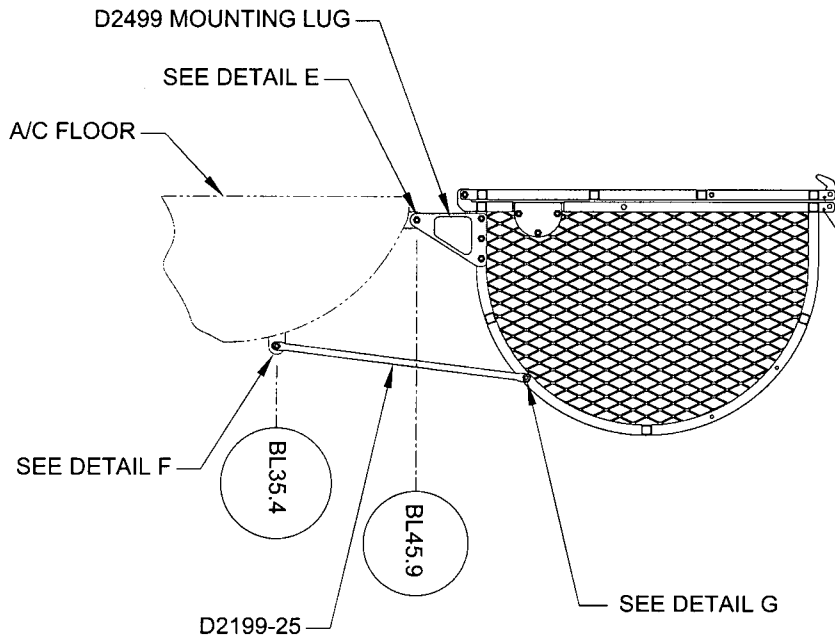
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Date: 08.03.04

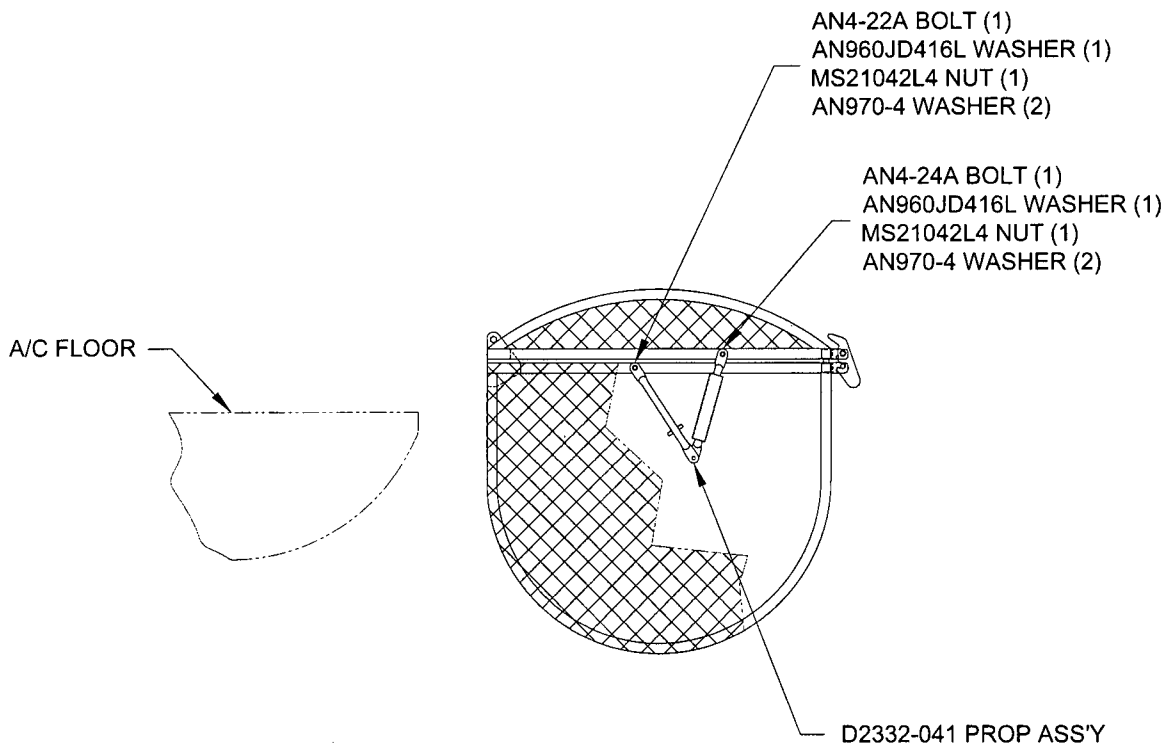


**Figure 4a – Section C-C Looking Fwd at STA 155.06**  
(D205-541-044 Shown; D205-541-043 Opposite)



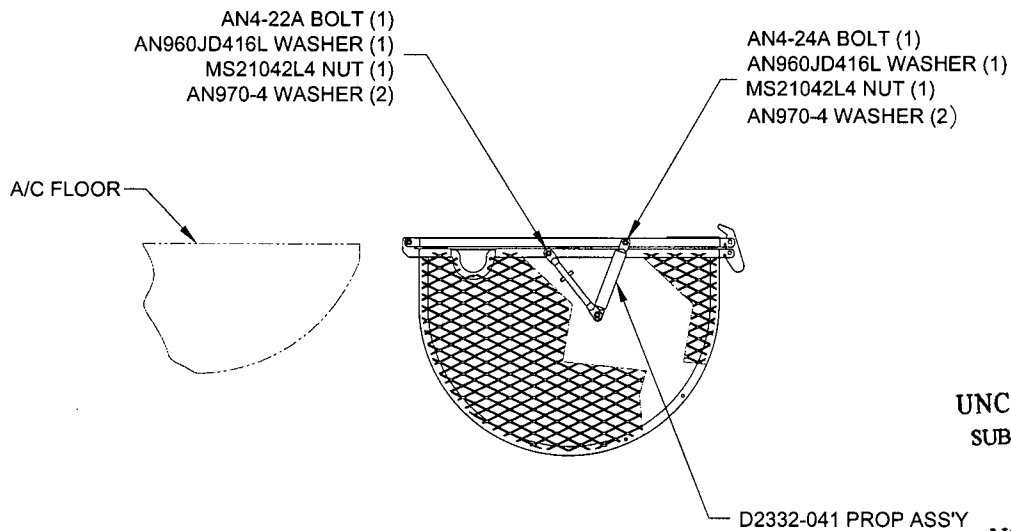
**Figure 4b – Section C-C Looking Fwd at STA 155.06**  
(D205-541-046 Shown; D205-541-045 Opposite)

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**Figure 5a – Section D-D Looking Fwd at STA 180.08**

(D205-541-044 Shown; D205-541-043 Opposite)



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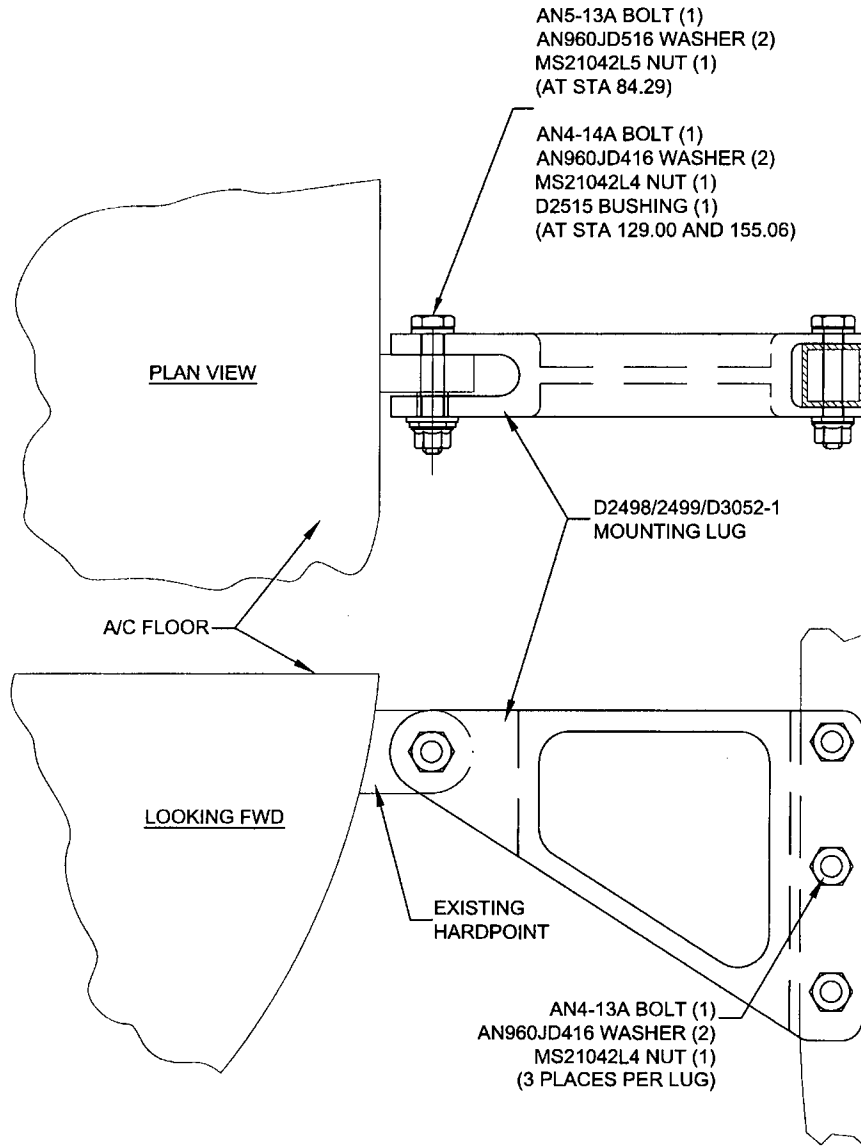
**Figure 5b – Section D-D Looking Fwd at STA 180.08**

(D205-541-046 Shown; D205-541-045 Opposite)

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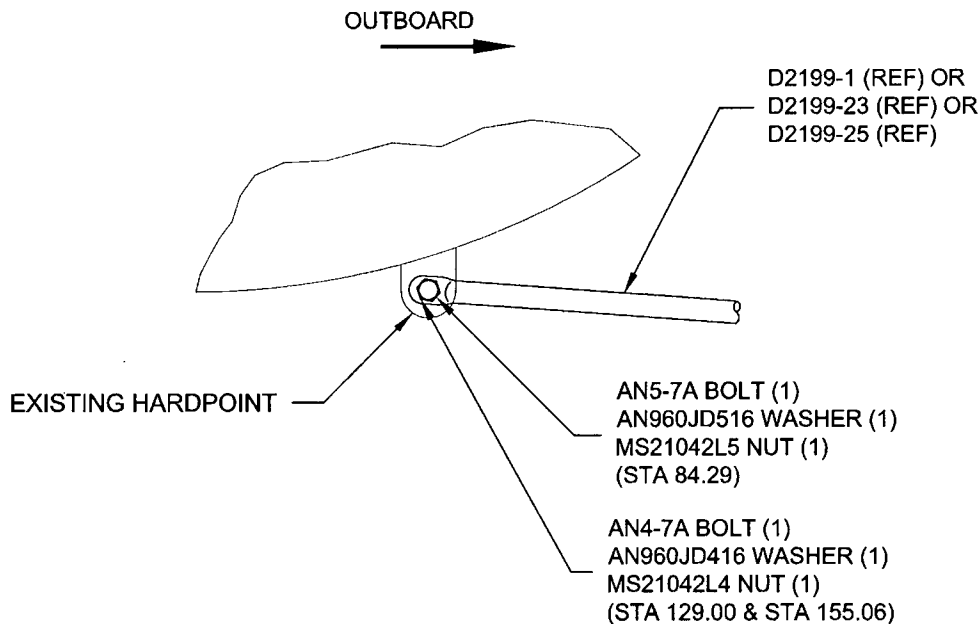
Revision: **G**

Date: 08.03.04

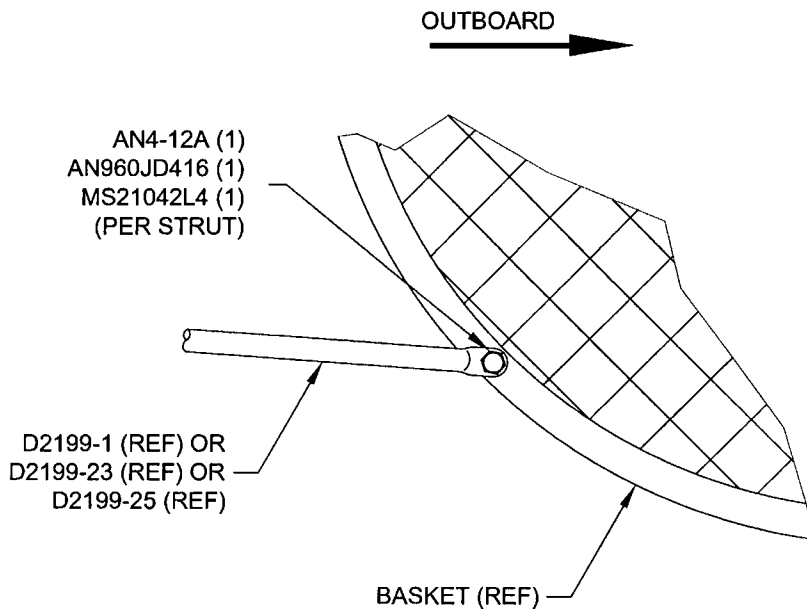


**Figure 6 – Detail 'E' Mounting Lug Installation**

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NO. 38216



**Figure 7 – Detail 'F' Strut to Hardpoint Attachment**  
(D205-541-044 & D205-541-046 Shown; D205-541-043 & D205-541-045 Opposite)



**Figure 8 – Detail 'G' Strut to Basket Attachment**  
(D205-541-044 & D205-541-046 Shown; D205-541-043 & D205-541-045 Opposite)

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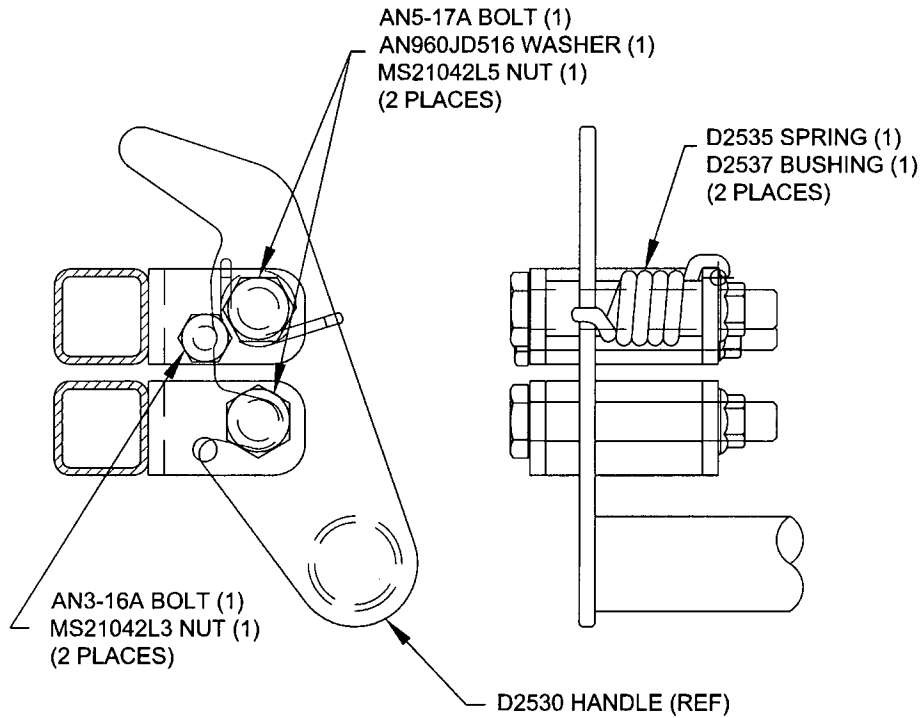


Figure 9 - Detail 'H' Handle Assembly

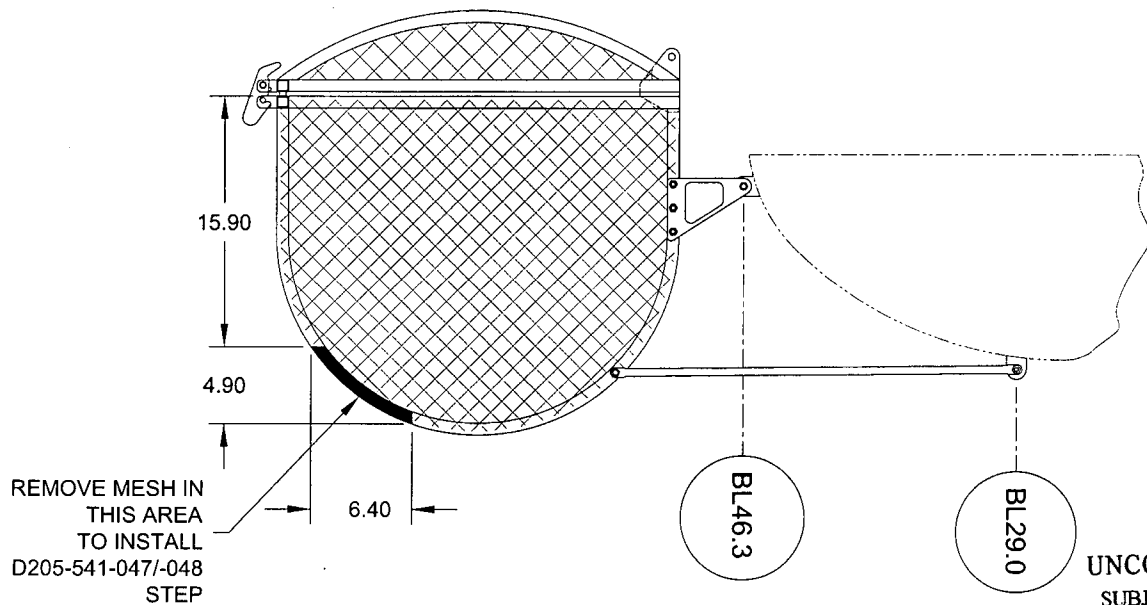
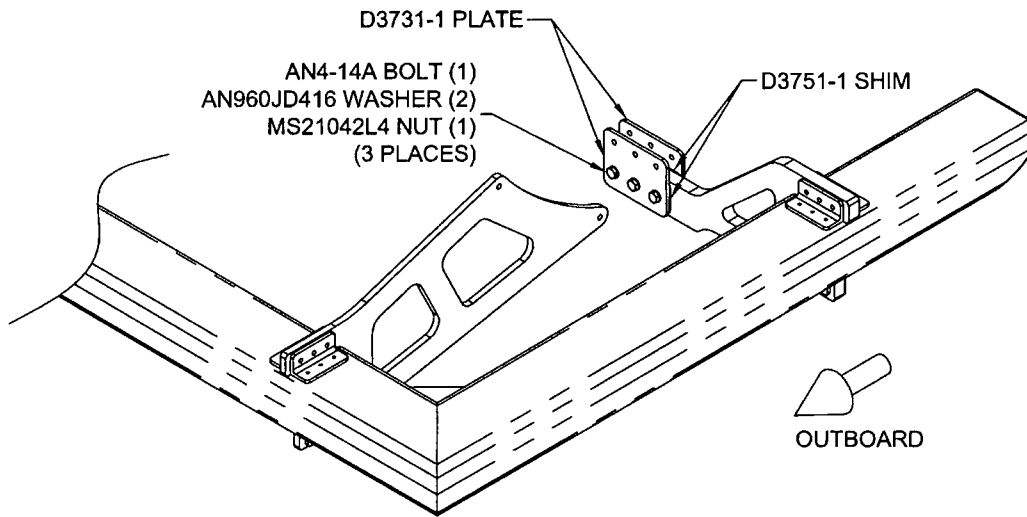
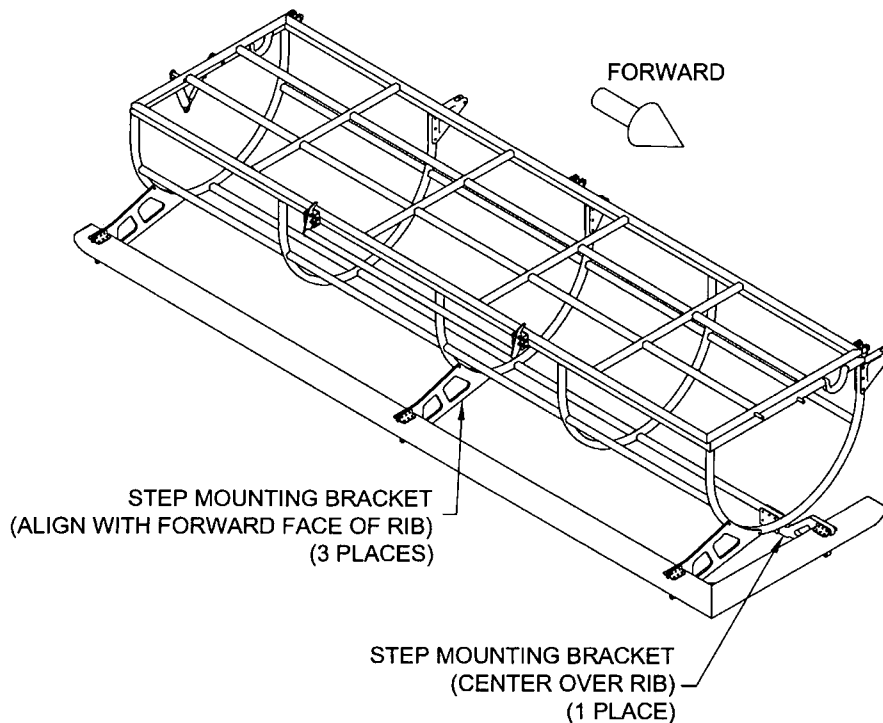


Figure 10 - Mesh Removal Looking Aft at STA 84.00  
(D205-541-044 Shown; D205-541-043 Opposite)

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**Figure 11 – Step Plate Assembly**  
(D205-541-048 Shown; D205-541-047 Opposite)



**Figure 12 – Step Alignment**

(D205-541-046 Heli-Utility-Basket™ with D205-541-048 Heli-Access-Step™ Shown;  
D205-541-045 Heli-Utility-Basket™ with D205-541-047 Heli-Access-Step™ Opposite)  
(D205-541-044 Heli-Utility-Basket™ with D205-541-048 Heli-Access-Step™ Similar;  
D205-541-043 Heli-Utility-Basket™ with D205-541-047 Heli-Access-Step™ Similar & Opposite)

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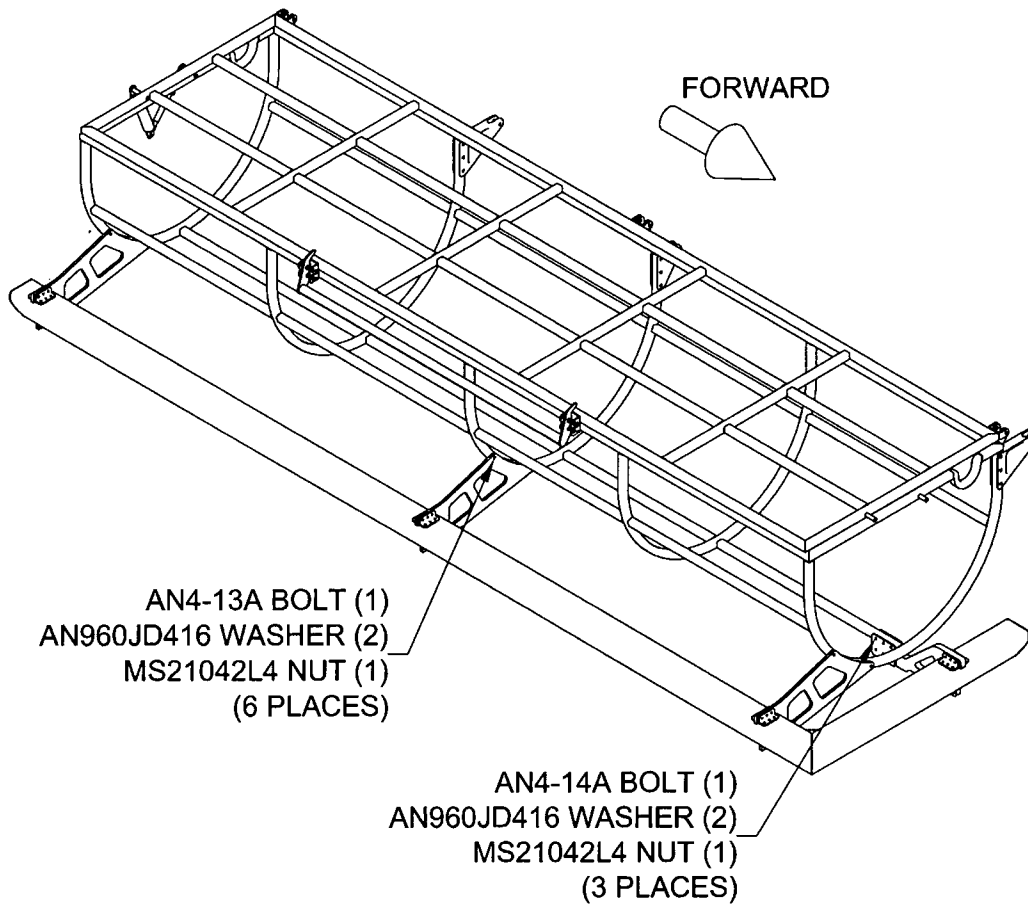


Figure 13 – Step Installation

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#### 4.0 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-541-043 <i>Heli-Utility-Basket™</i>	118 lb 53.6 kg	- 63.13 in - 1.60 m	- 7449 in-lb - 85.8 m-kg	132.25 in 3.36 m	15606 in-lb 180.1 m-kg
D205-541-044 <i>Heli-Utility-Basket™</i>	118 lb 53.6 kg	+ 63.13 in + 1.60 m	+ 7449 in-lb + 85.8 m-kg	132.25 in 3.36 m	15606 in-lb 180.1 m-kg
D205-541-045 <i>Heli-Utility-Basket™</i>	104 lb 47.3 kg	- 63.13 in - 1.60 m	- 6566 in-lb - 75.7 m-kg	132.25 in 3.36 m	13754 in-lb 158.9 m-kg
D205-541-046 <i>Heli-Utility-Basket™</i>	104 lb 47.3 kg	+ 63.13 in + 1.60 m	+ 6566 in-lb + 75.7 m-kg	132.25 in 3.36 m	13754 in-lb 158.9 m-kg
D205-541-047 <i>Heli-Access-Step™</i>	14 lb 6.4 kg	- 59.63 in - 1.51 m	- 834 in-lb - 9.7 m-kg	126.56 in 3.21 m	+ 1772 in-lb + 20.5 m-kg
D205-541-048 <i>Heli-Access-Step™</i>	14 lb 6.4 kg	+ 59.63 in + 1.51 m	+ 834 in-lb + 9.7 m-kg	126.56 in 3.21 m	+ 1772 in-lb + 20.5 m-kg

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